

**Work Order ID 62748**

Thursday, October 07, 2010 3:08:51 PM

Page 1

Item ID: D206-628-023

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step LH

Start Date: 10/7/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-07

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels as per PPP D206-628-023 CHG 003

8 / M 10 11 16 (4)  
10/10/10 HJ for BG 10-11-12

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

10/11/12 S (40)

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8 / M 10 11 16 (4)  
10/10/10 S 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62748**

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Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step LH

Start Date: 10/7/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-628-023 Location: <u>11</u> PPP Rev: <u>4</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/16  
42

10/11/16

CMF  
10-11-16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 62748

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010


Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM  
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC  
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A		Purchased	No			120	Each	1,650.000	3	12			
													
BOLT													

Location	Loc Qty	Loc Code
ST245	20	
110139	20	
ST303	42	
115438	42	
ST350	1588	
114108	14	
114416	12	
114523	2	
115300	560	
115589	1000	

AN4C14A		Purchased	No			120	Each	87.0000	4	16			
													
Bolt													

Location	Loc Qty	Loc Code
ST358	87	
111902	17	
115767	40	
115835	30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 62748

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

120

Each

127.0000

8

32

Bolt

## Location

## Loc Qty

## Loc Code

ST358

127

114442

1

115457

26

115835

100

AN960C10

NAS1149C0363

Purchased

No

120

Each

0.0000

3

12

WASHER

AN960C416L

Purchased

No

120

Each

180.0000

24

96

WASHER

## Location

## Loc Qty

## Loc Code

FG

44

104925

44

ST346

136

106785

10

107008

10

112828

75

69220

41

D2731-7

Manufactured

No

120

Each

39.0000

4

16

Mounting Lug

## Location

## Loc Qty

## Loc Code

ST420

15

60996

15

ST470

24

61653

24

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62748

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D2732

Manufactured No

120 f

216.4157 2 8



Rubber Extrusion

Location

Loc Qty

Loc Code

ST412

216.415737

43118

2.5

56516

213.915737

(D2732-030) Cut (8) at 3.00"

D2842-041

Manufactured No

120 Each

2.0000 .1 4



Step Assembly, 206 Float

Location

Loc Qty

Loc Code

ST

2

61045

2

D2844-1

Manufactured No

120 Each

1.0000 2 8



Arm

Location

Loc Qty

Loc Code

ST265

1

52030

1

D2844-3

Manufactured No

120 Each

9.0000 1 4



Arm

Location

Loc Qty

Loc Code

ST265

9

61453

9

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 62748

Parent Item: D206-628-023

Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured No

120 Each

49.0000 4

1 16 (10x)



Lug Assembly



B62667 10/11/10

Location

Loc Qty

Loc Code

ST420

19

60997

19

ST475

30

62005

30

MS21043-4

Purchased No

120 Each

783.0000 12

6x 48 10/11/12



Nut



Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

743

112492

25

113069

8

114523

410

114784

300

48

NAS1515H3

Purchased No

120 Each

98.0000 3

12



Washer



10/11/12 5/4

Location

Loc Qty

Loc Code

ST277

98

111268

4

115675

94

12

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4L

Purchased

No

120

Each

456.0000

24

96



WASHER



10/11/10 5/40

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

416

112492

11

114236

48

114265

357

90

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

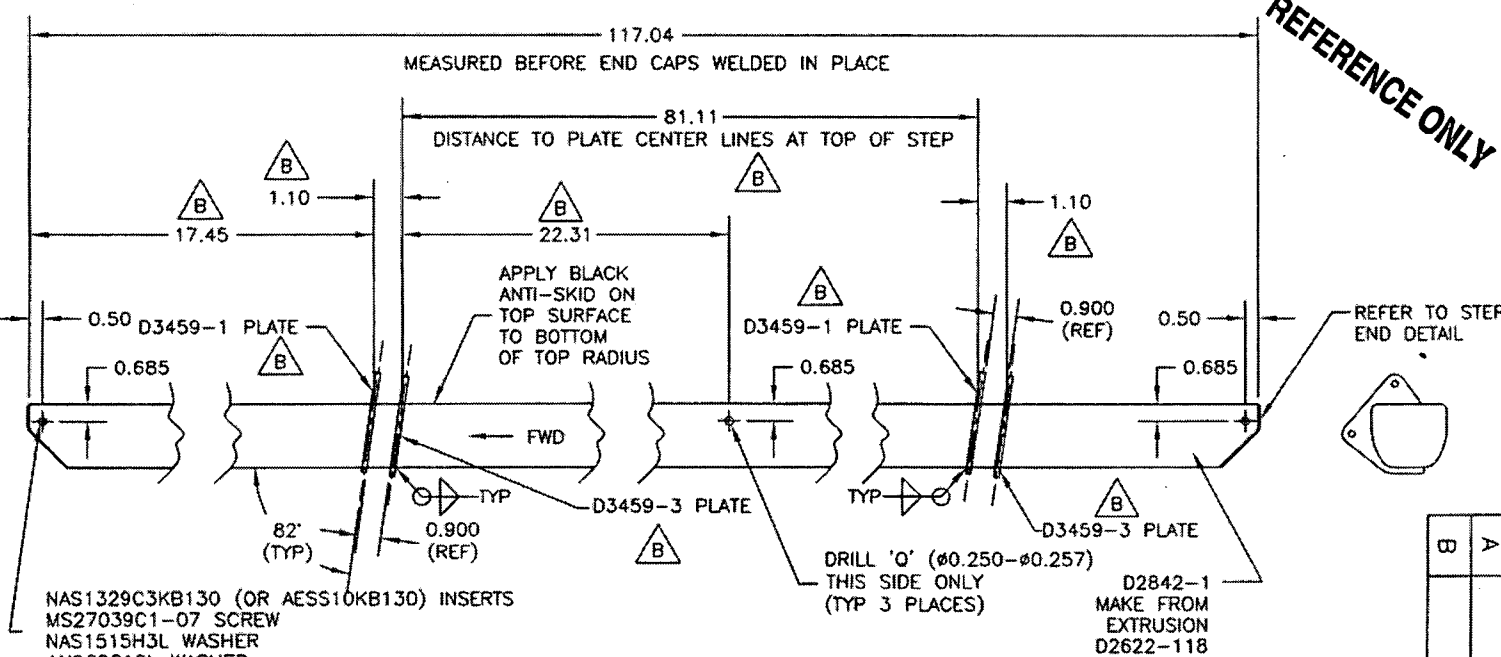
Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

**DART**

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
				SHEET 1 OF 1
				SCALE
				206L/407 FLOAT STEP ASSEMBLY
				NTS
				RE-DESIGN, ADD D3459-1/-3
				NEW ISSUE
				98.10.13
				05.09.23
				B

REFERENCE ONLY

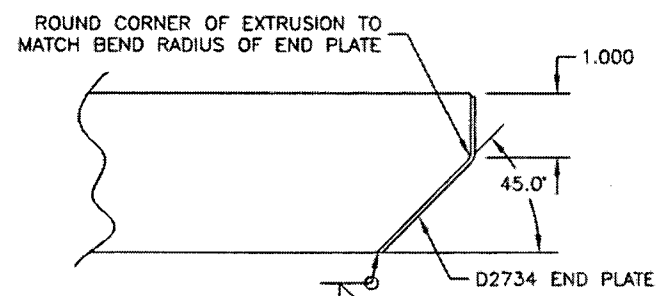


NAS1329C3KB130 (OR AESS10KB130) INSERTS  
MS27039C1-07 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)  
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



**D2842-041/-042 FLOAT STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05-11-14

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